

Date: Thursday, 29/11/2007 10:50:26 AM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : REWORK
Job Number : 36067	
Estimate Number : 10804	
P.O. Number : N/A	Part Number : D205596103
This Issue : 29/11/2007 S.O. No. : N/A	Drawing Number : ECN 1075/DSI 9396
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LANDING GEAR	Drawing Revision : N/A
Previous Run : 36066	Material : N/A
Written By : _____	Due Date : 20/12/2007 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : _____	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

REMOVE FROM STOCK:

1 X D205-596-103 B33983

2.0

D205596103

Crosstube Aft Extended



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Crosstube Aft Extended

3.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1 Magnabond B105379 exp: 05/2008 Time: 10:00 AM

REMOVE SUPPORTS AND CLAMPS

USE SAME TO RE-INSTALL PER

DSI 9396 / ECN 1075

APPLY MAGNOBOND UNDERNEATH SUPPORT B 105379

RE-INSTALL SUPPORTS PER DSI 9396

INSTALL A D3595-063-450/-530 RUBBER CUSHION B 35125



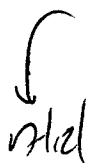





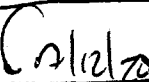

ON EACH CLAMP MS21920

RE-INSTALL PER DSI 9396 / ECN 1075

ml 07 12 13 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/01/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/10	#3.0	when supports were removed it was discovered that the Paint was too thick. R.C. Hammerman error		Strip entire tube of paint using paint stripper	 07-12-12	 07/12/10	 07/12/10	 07/12/10
				Re prime was out side w/1. Enron. BPS	 07-12-12			
				ASZ 005				
				Re paint with Enron ASZ 005	 07-12-12			
				Re inspect QC #14	1/4	 07/12/10		 07/12/10

NOTE: Date & initial all entries

Date: Thursday, 29/11/2007 10:50:26 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: REWORK

Job Number: 36067

Part Number: D205596103

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5/12/20 (10)

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
RE-PACKAGE PER PPP
USING NEW B/N
NEW LABELS REQUIRED

Rev 9 1/12/27 SD (12)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



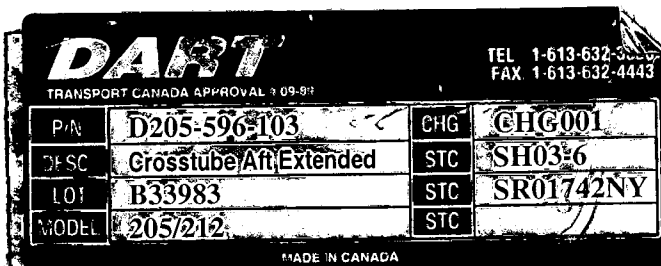
Comment: FINAL INSPECTION/W/O RELEASE

(1)
D08101/03

Job Completion



mi 2008/1/2
H



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-594 Rev. C (AND EARLIER) AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-594 Rev. 2 (AND EARLIER)
REF. CANADIAN STC: SH03-6
REF. FAA STC: SR01742NY

For D205-596-101/-103 Crosstubes (ref. 39" Landing Gear) or D205-596-105/-107 Crosstubes (ref. 31" Landing Gear) at CHG 002 or later, the D2856-600-851/-1009 Abrasion Strips have been removed, the D2893-1 and D2940-1 Supports have been bonded onto the crosstubes using Magnobond 6398 and D3595-063-450/-530 Rubber Cushions have been installed underneath the MS21920-26/-30 Clamps. Amend Parts List of IIN-D205-594 Section 5 and ICA-D205-594 Section 32.8 as follows:

Remove:

QTY -101	QTY -103	QTY -105	QTY -107	Part Number	Description
2		2		D2856-600-851	ABRASION STRIP
4		4		MS21920-24	CLAMP
	2		2	D2856-600-1009	ABRASION STRIP
	4		4	MS21920-28	CLAMP


Add:

QTY -101	QTY -103	QTY -105	QTY -107	Part Number	Description
4		4		D3595-063-450	RUBBER CUSHION
4		4		MS21920-26	CLAMP
	4		4	D3595-063-530	RUBBER CUSHION
	4		4	MS21920-30	CLAMP

To prevent the supports from shifting on D205-596-101/-103/-105/-107 Crosstubes at CHG 001, the D2893-1 or D2940-1 Supports should be removed and re-installed as follows:

- Follow section 32.1 of ICA-D205-594 for the removal of the crosstubes from the helicopter.
- Remove the MS21920-24/-28 Clamps that fasten the D2893-1 and D2940-1 Supports from the crosstubes per Section 32.3 of ICA-D205-594.
- Remove the D2856-600-851/-1009 Abrasion Strips from the crosstube per section 32.5 of ICA-D205-594.
- Inspect the crosstube surface underneath the supports for corrosion and mechanical damage per items 5.3.1 and 5.3.2 of the 300 hour inspection. Repair damage within acceptable limits and touch up finish per item 5.3.3 of the 300 hour inspection.
- Inspect the supports for corrosion and mechanical damage per items 5.3.4 of the 300 hour inspection. Repair damage within acceptable limits and touch up finish per item 5.3.4 of the 300 hour inspection.
- Abrade area to which support will be applied with 400 grit sandpaper. Saturate a clean cloth with MEK or 4105S Wash'n'Wipe Degreaser or equivalent and wipe area until there is no residue.
- Apply a 0.03" to 0.06" thick layer of Magnobond 6398 underneath D2893-1 or D2940-1 Supports and re-install the Supports on the crosstube as shown in Figure 1. Install a D3595-063-450/-530 Rubber Cushion on each MS21920-26/-30 Clamp. Position and secure the D2893-1 or D2940-1 Supports on the crosstube using MS21920-26/-30 Clamps. Torque clamps to 80-100 in-lb. Let the D205-596-101/-103/-105/-107 Crosstube Assembly cure before re-installing the crosstube on the aircraft.
- Re-install the D205-596-101/-103/-105/-107 crosstube per section 32.2 of ICA-D205-594.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)
DATE: 07.11.16
CERT. NO.: SH03-6
ISSUE NO.: 3

A	NEW ISSUE	MB	07.11.16
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9396	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE SUPPORT CHANGE	NTS
DATE	07.11.16	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

For customers who would like to upgrade their D205-596-101/-103/-105/-107 Crosstubes from CHG 001 to CHG 002, the following kits can be obtained from Dart:

DSI 9396-XXX PARTS LIST

QTY -011	QTY -013	Part Number	Description
X		DSI 9396-011	FWD CROSSTUBE SUPPORT CHANGE (D205-596-101/-105 FWD CROSSTUBE)
	X	DSI 9396-013	AFT CROSSTUBE SUPPORT CHANGE (D205-596-103/-107 AFT CROSSTUBE)
4		D3595-063-450	RUBBER CUSHION
4		MS21920-26	CLAMP
	4	D3595-063-530	RUBBER CUSHION
	4	MS21920-30	CLAMP

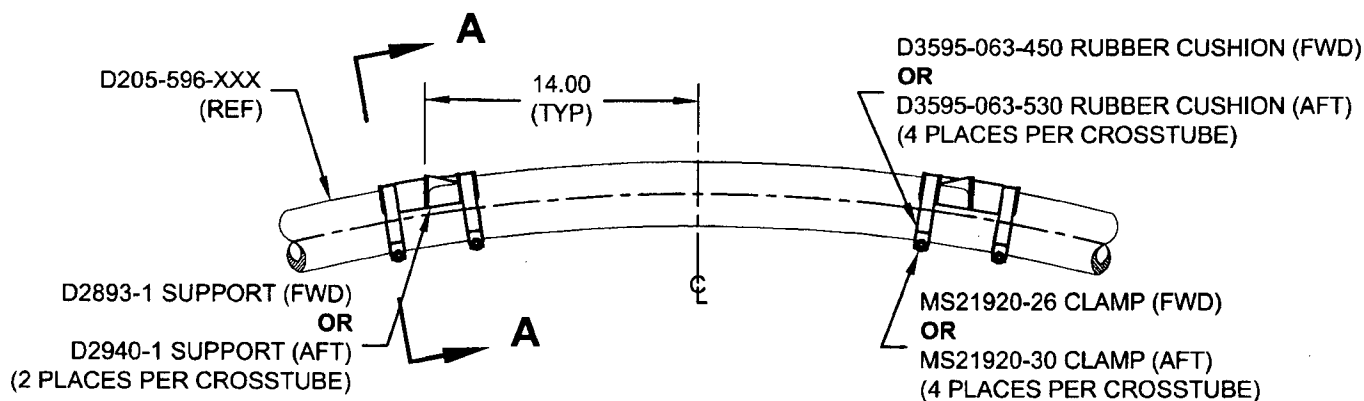
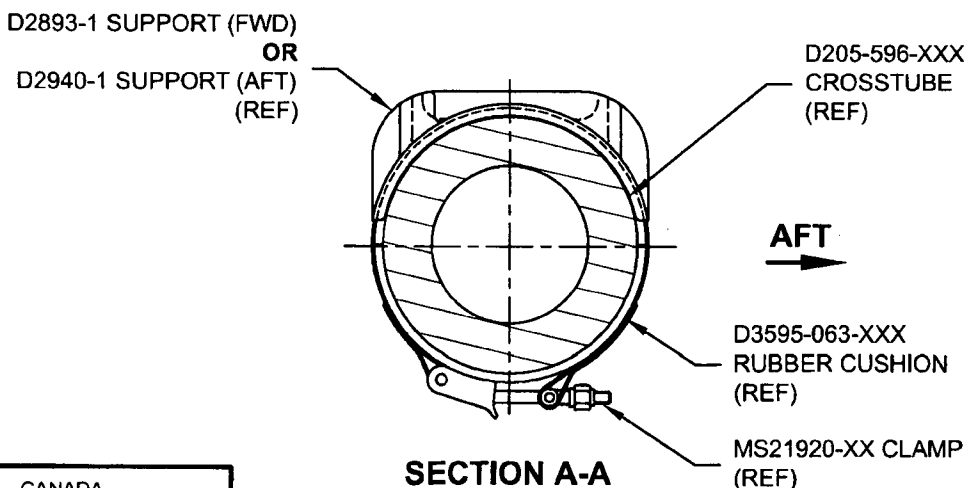


FIGURE 1: INSTALLATION OF SUPPORT ON CROSSTUBE




CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 07.11.16
CERT. NO.: SH03-6
ISSUE NO.: 3

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	DSI 9396	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CROSSTUBE SUPPORT CHANGE	NTS
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Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D205-596
Job Number	: 36810		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: Z_CUSTOM
This Issue	: 17/01/2008 S.O. No. :	Drawing Number	: ECN 1108
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : LANDING GEAR	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	:	Due Date	: 24/01/2008 Qty: 1 Um: Each
Checked & Approved By	: 		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

REMOVE FROM STOCK

D205-596-101

32941-34946-34947

D205-596-103

35427-35429-36067-36068

D205-596-105

D205-596-107

35224-

ADD NEW PAPERWORK TO KITS
DSI 9396 REV.B, PER ECN 1108

RETURN TO STK

8/1/15 SP (8x)

2.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

15080121

Job Completion



2008/1/21

